

Work Order ID 65040

Wednesday, January 05, 2011 3:04:36 PM



Page 1

Item ID: D4010-041

Accept



Setup Start



Revision ID:

Item Name: Bearpaw Assembly

Stop



Start Date: 1/5/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date: 11-01-5

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4010

D

100

0.00



Pick Kit

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Pick Kit

x4

DL
11/02/02

110

0.00



Assembly

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1- Use wearbar to transfer drill hole and open to finish size as per dwg
2-- Deburr
3- Assemble as per Dwg D4010
4-Install wearplates as per dwg.

x4

DL
11/02/02

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

DL

x4

pho →

DL
11/02/02

W/O: 65040		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/02/03	# 120	Remove step # 120 Qc2 it was no use there no FAF need on this part.	MS	11.02.08			S 4/02/03

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Customer:

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Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sulzer

74

140

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

PPC 65039

Rec'd 2 (4)

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/08

MF
11-02-07

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NOTE: Date & initial all entries

Picklist Print

Wednesday, January 05, 2011 3:04:40 PM

Page 1

Work Order ID: 65040

Parent Item: D4010-041

Parent Item Name: Bearpaw Assembly




Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevB: 09/11/03 Drawing changed to accomidate OEM and Dart Skidtube.
DL. Verified by:DD IPP Rev. C Dwg.
Redesign 09/11/012 DL VERIFIED BY:DD IPP Rev:D 10.05.27 per
ECN10-575 DL verf:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status																											
AN3C5A  Bolt		Purchased	No			100	Each	966.0000	5	20																														
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST350</td><td>966</td><td></td></tr><tr><td>114330</td><td>11</td><td></td></tr><tr><td>115015</td><td>13</td><td></td></tr><tr><td>115371</td><td>100</td><td></td></tr><tr><td>115422</td><td>100</td><td></td></tr><tr><td>115594</td><td>6</td><td></td></tr><tr><td>115835</td><td>236</td><td></td></tr><tr><td>116419</td><td>500</td><td></td></tr></table>														Location	Loc Qty	Loc Code	ST350	966		114330	11		115015	13		115371	100		115422	100		115594	6		115835	236		116419	500	
Location	Loc Qty	Loc Code																																						
ST350	966																																							
114330	11																																							
115015	13																																							
115371	100																																							
115422	100																																							
115594	6																																							
115835	236																																							
116419	500																																							
D3456-1  Washer		Manufactured	No			100	Each	112.0000	3	12																														
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST058</td><td>112</td><td></td></tr><tr><td>63239</td><td>12</td><td></td></tr><tr><td>64282</td><td>100</td><td></td></tr></table>														Location	Loc Qty	Loc Code	ST058	112		63239	12		64282	100																
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ST058	112																																							
63239	12																																							
64282	100																																							
D4010-1  Bearpaw		Manufactured	No			100	Each	0.0000	1	4																														

Batch 65041

11/02/02

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 2

Work Order ID: 65040

Parent Item: D4010-041

Parent Item Name: Bearpaw Assembly

Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 4.00

Required Qty: 4.00

D4013-041 Manufactured No

100 Each

18.0000

1

4



Wearplate Assembly

Location

Loc Qty

Loc Code

ST256

18

53880

8

54444

10

4

D4015-041 Manufactured No

100 Each

44.0000

5

20



Wearbar Weldment

Location

Loc Qty

Loc Code

ST114

44

63690

44

20

MS21043-3 Purchased No

100 Each

1,731.000

5

20



Nut

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

1655

112314

1655

20

MS21043-4 Purchased No

100 Each

895.0000

3

12



Nut

Location

Loc Qty

Loc Code

ST301

895

114523

5

114784

2

115936

292

116188

596

12

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Shop Packet Print

Page 2

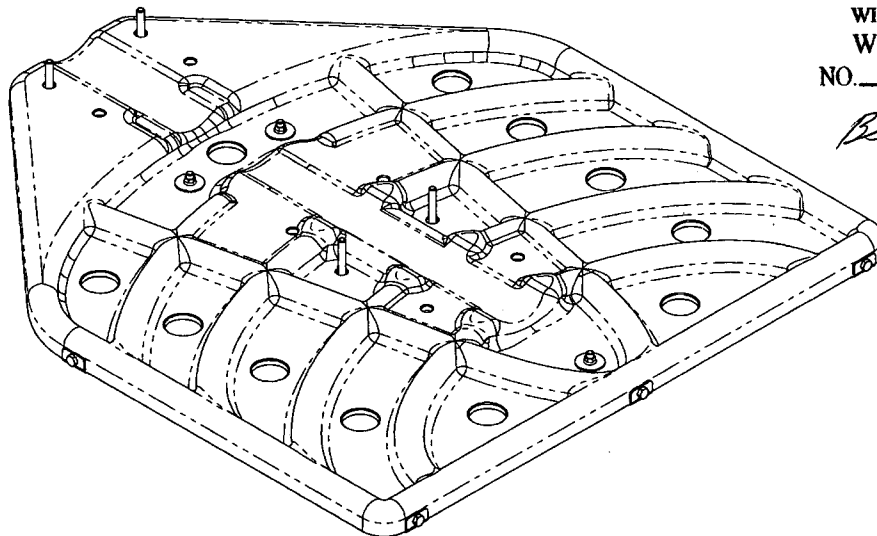
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SHOP COPY
RETURN TO:
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65040

BS 10-01-5

RELEASED
2010-05-26
WJD

D4010-041 BEARPAW ASSEMBLY (407)

D	CHANGED NOTE 9 ON SHEET 3 (ZN A3-3); CHANGED Ø0.375 HOLE LOCATIONS FROM HARD CALL OUT TO REF (ZNS D5-3, D6-3, D7-3); ADDED CHAMFERS TO ALL DRILLED HOLES (ZN B4-3, 2 PL). REMOVED BOSSES ON BOTTOM SURFACE AROUND Ø1.250 HOLES (ZN D4-3 ON PREVIOUS REV'S); PICTORIAL CHANGE ON D4010-1 TO REFLECT MOLD REWORK (RECESSES FOR CLEARANCE OF BOTTOM SADDLE EDGE AND RIVET HEADS ON OEM SKIDTUBES). REASON: SEE PAR#10-020.	MB	10.05.14
C	OPTIMIZED DESIGN BASED ON FUNCTIONALITY AND TO EASE MANUFACTURING	MB	09.11.10
B	REDESIGNED; ADDED PROVISIONS FOR COMPATIBILITY WITH OEM SKIDTUBES/SADDLES; REDEFINED SOME TOLERANCE	MB	09.11.02
A	NEW ISSUE	MB	09.10.22
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4010 REV. D SHEET 1 OF 3 TITLE BEARPAW (407) SCALE NTS <small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	10.05.14		

W/O:		WORK ORDER CHANGES					
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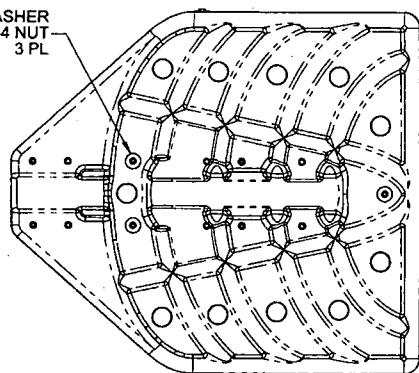
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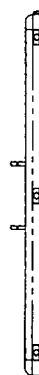
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D3456-1 WASHER
MS21043-4 NUT
3 PL



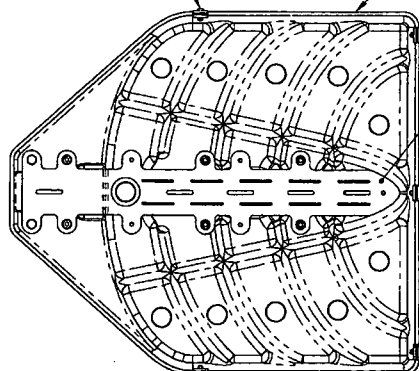
1.0 TYP 8



10.5 8

14.0 TYP 8

8 AN3C5A BOLT
D4015-041 WEARBAR
MS21043-3 NUT



D4010-1 BEARPAW

AN3C5A BOLT 8
D4015-041 WEARBAR
MS21043-3 NUT

D4013-041 WEARPLATE
ASSEMBLY

AN3C5A BOLT 8
D4015-041 WEARBAR
MS21043-3 NUT

AN3C5A BOLT 8
D4015-041 WEARBAR
MS21043-3 NUT

8 AN3C5A BOLT
D4015-041 WEARBAR
MS21043-3 NUT

D4010-041 BEARPAW ASSEMBLY (407)

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4010-041	BEARPAW ASSEMBLY (407)
2	3	D3456-1	WASHER
3	1	D4010-1	BEARPAW
4	1	D4013-041	WEARPLATE ASSEMBLY
5	5	D4015-041	WEARBAR
6	5	AN3C5A	BOLT
7	5	MS21043-3	NUT
8	3	MS21043-4	NUT

w/o 65040

RELEASED
2010-05-28

D4010-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 9.37 lbs
- 8) LOCATE D4015-041 (ITEM 5) AS SHOWN AND TRANSFER DRILL Ø0.191 HOLE FROM D4015-041 TO D4010-1 BEARPAW AND FASTEN USING PRESCRIBED HARDWARE.
- 9) TORQUE: AN3 NUTS = 15-20 in-lb
AN4 NUTS = 50-70 in-lb

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4010	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BEARPAW (407)	NTS
DATE	10.05.14	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

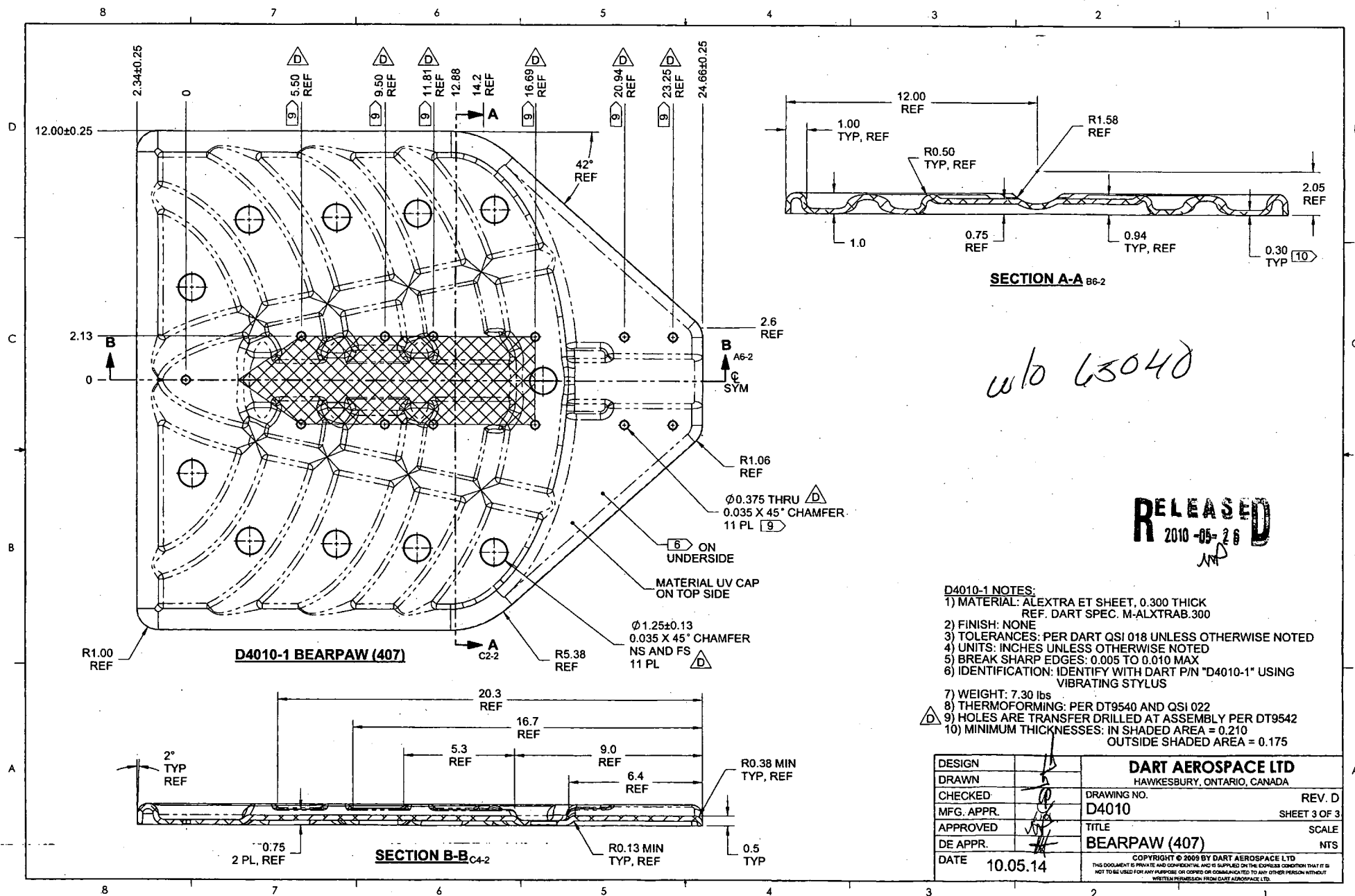
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